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(54) BIT GAGE HARDFACING

(76) Inventors: **James L. Overstreet**, Tomball, TX (US); **Robert J. Buske**, The Woodlands, TX (US); **Rudolf C. Pessier**, The Woodlands, TX (US); **Jeremy K. Morgan**, Midway, TX (US)

Correspondence Address:
James E. Bradley
BRACEWELL & PATTERSON, LLP
P.O. Box 61389
Houston, TX 77208-1389 (US)

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(57) **ABSTRACT**

An earth boring bit has at least one rotatable cone with a gage surface that engages a sidewall of a wellbore as the bit rotates. The gage surface has hardfacing bars spaced circumferentially apart from each other. A first group of the hardfacing bars extends from the inner edge of the gage surface to gage sides of the heel row cutting elements. A second group of the hardfacing bars extends from the inner edge of the gage surface to spaces between the heel row cutting elements, forming trimmer cutting elements. The hardfacing bars are made up of carbide particles in a metallic matrix.

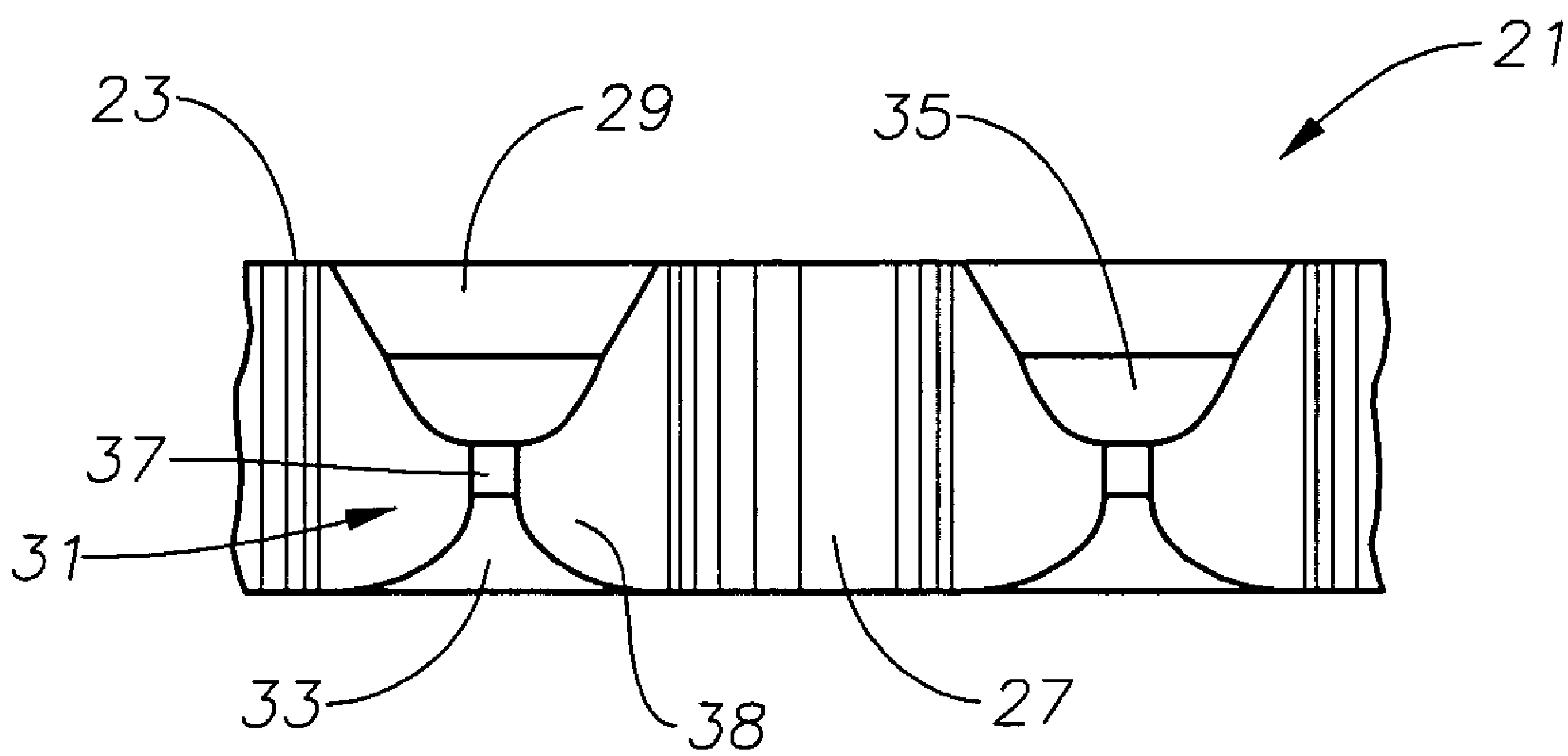
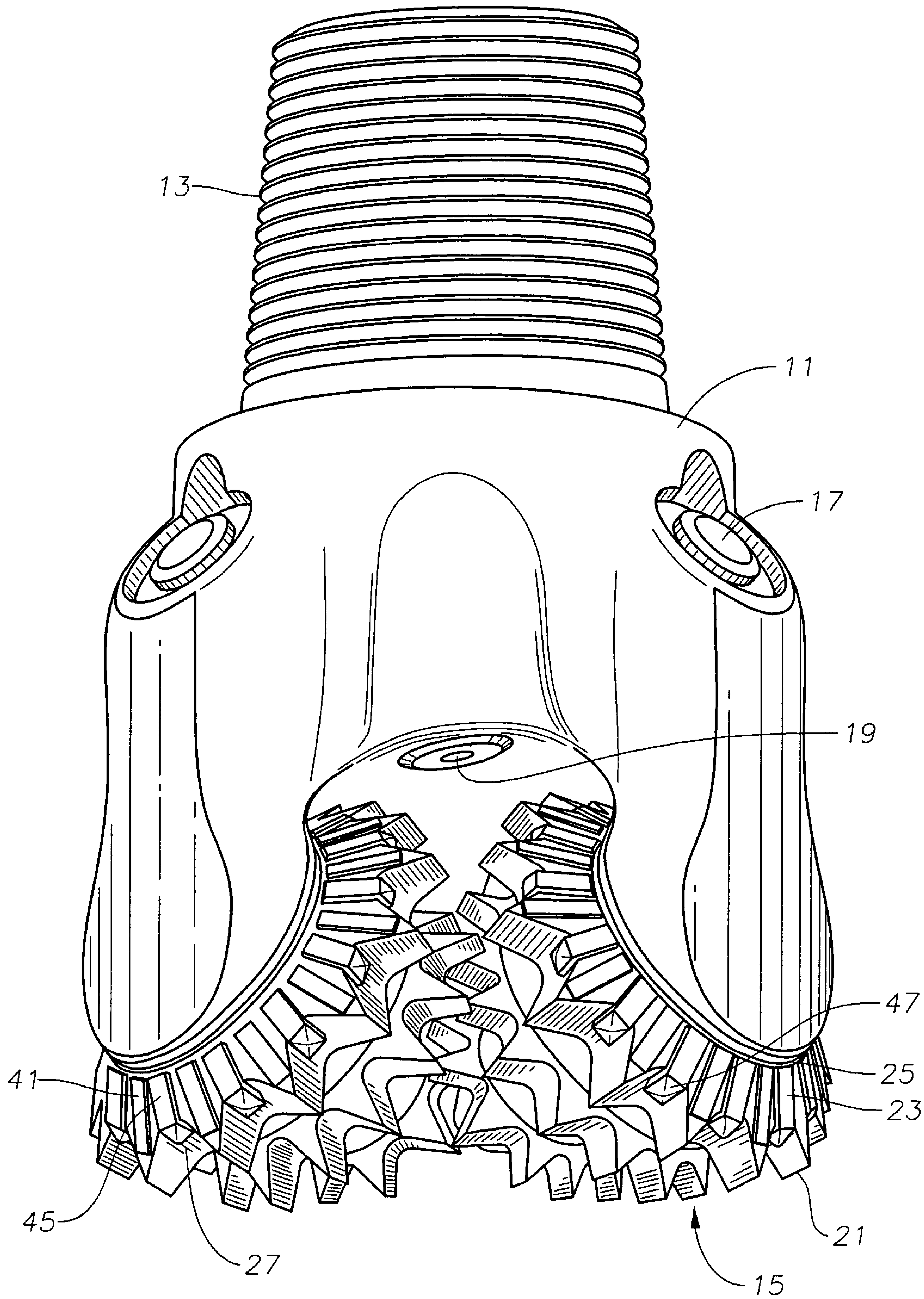


Fig. 1



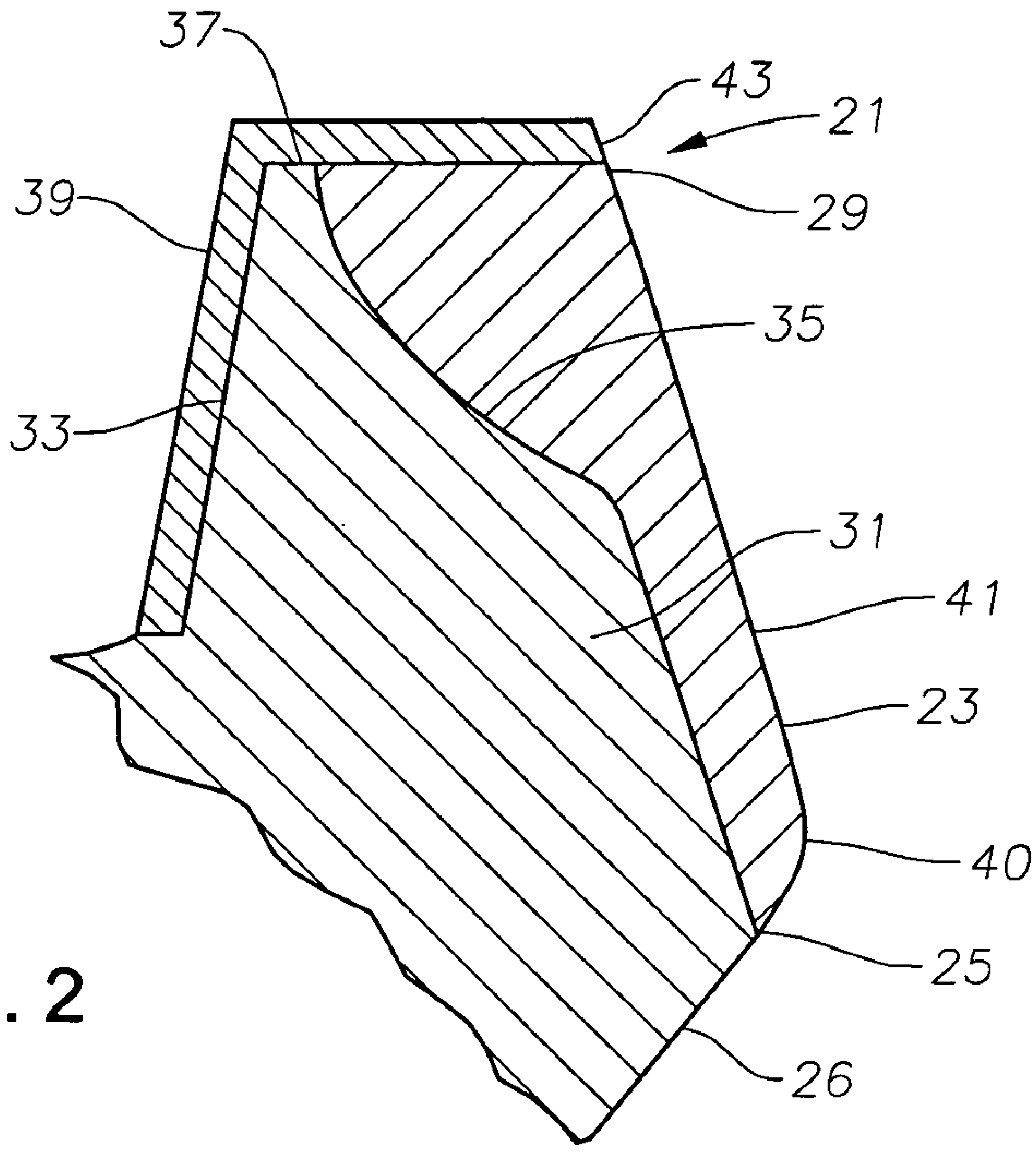

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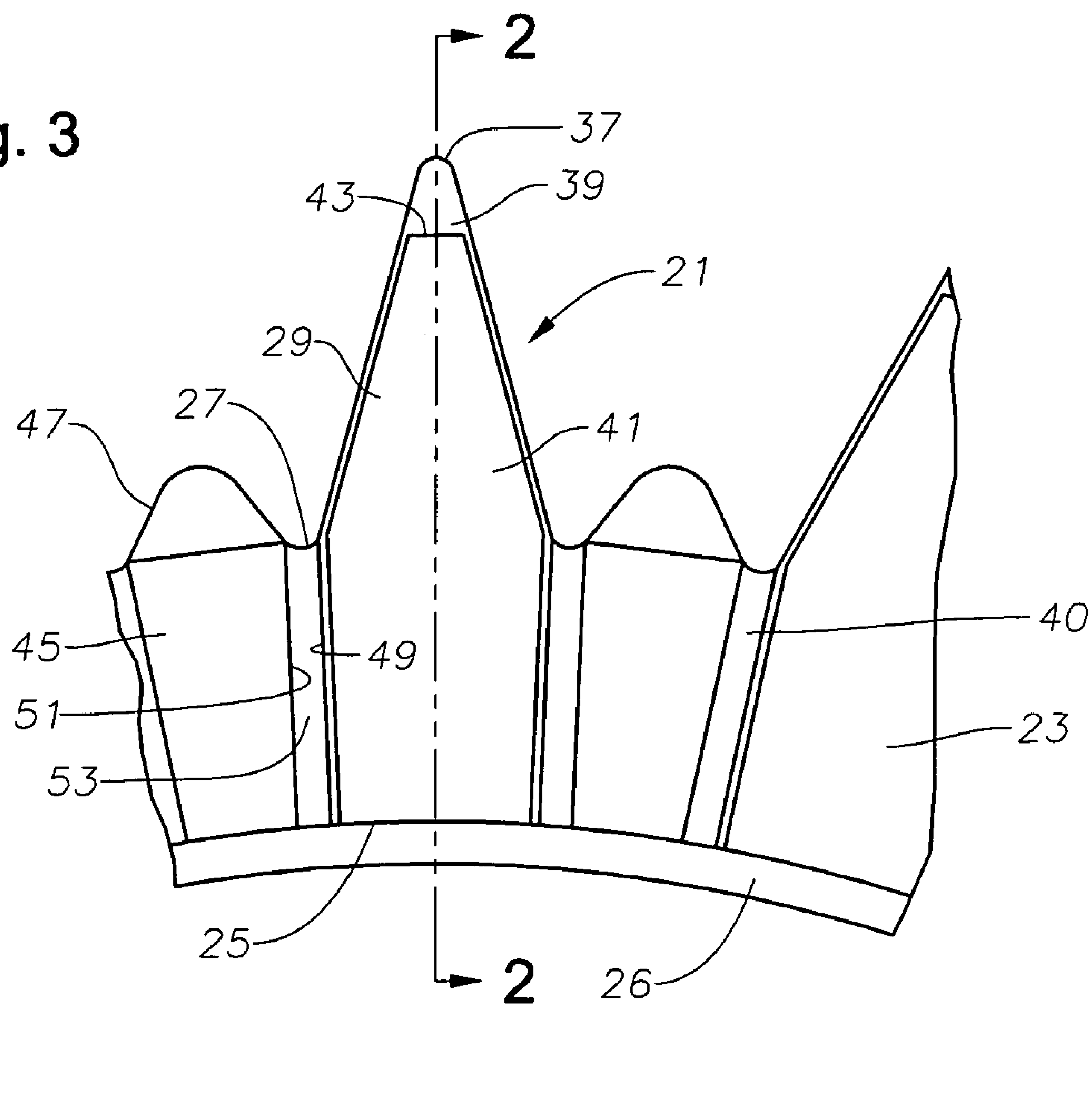
Fig. 2

Fig. 3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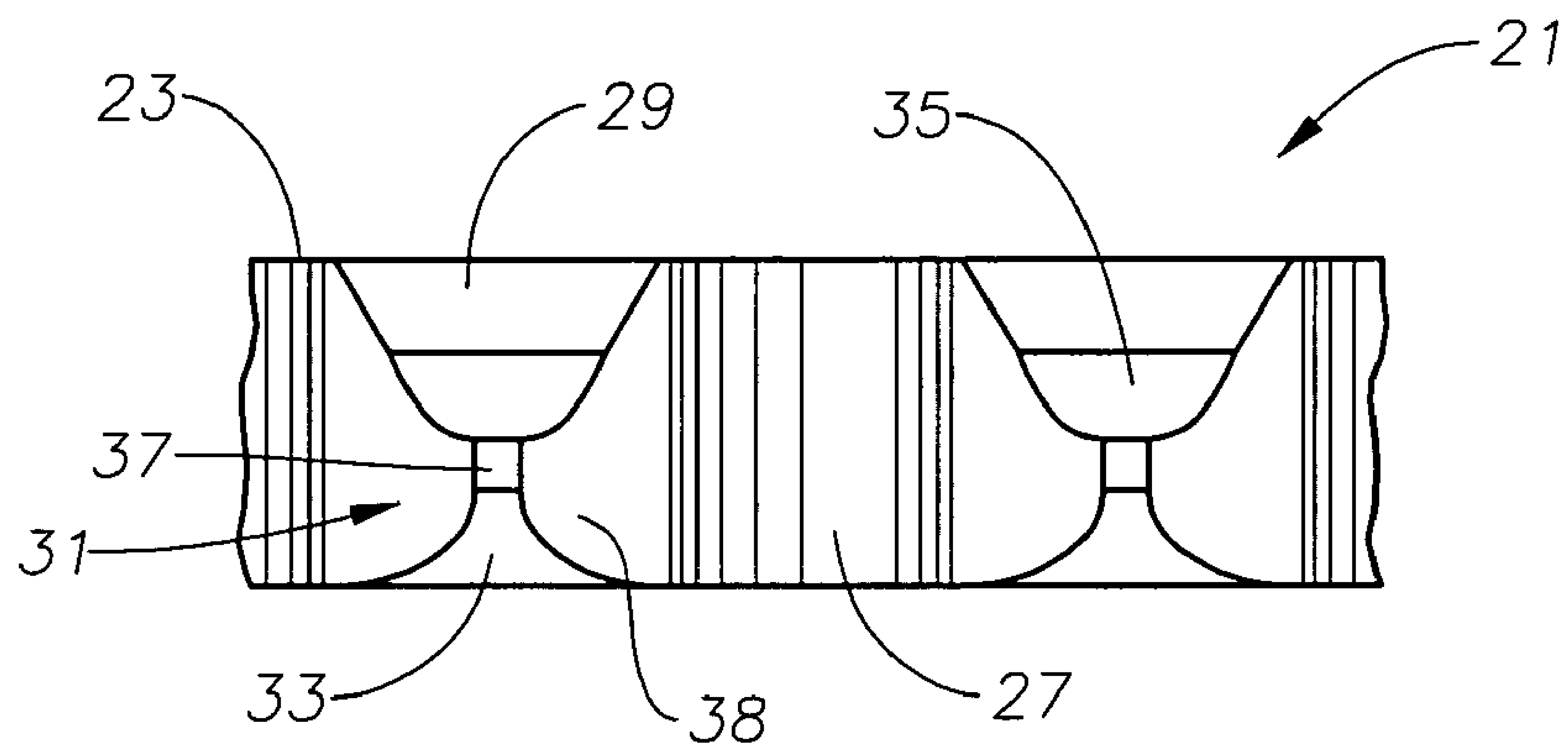

Fig. 4

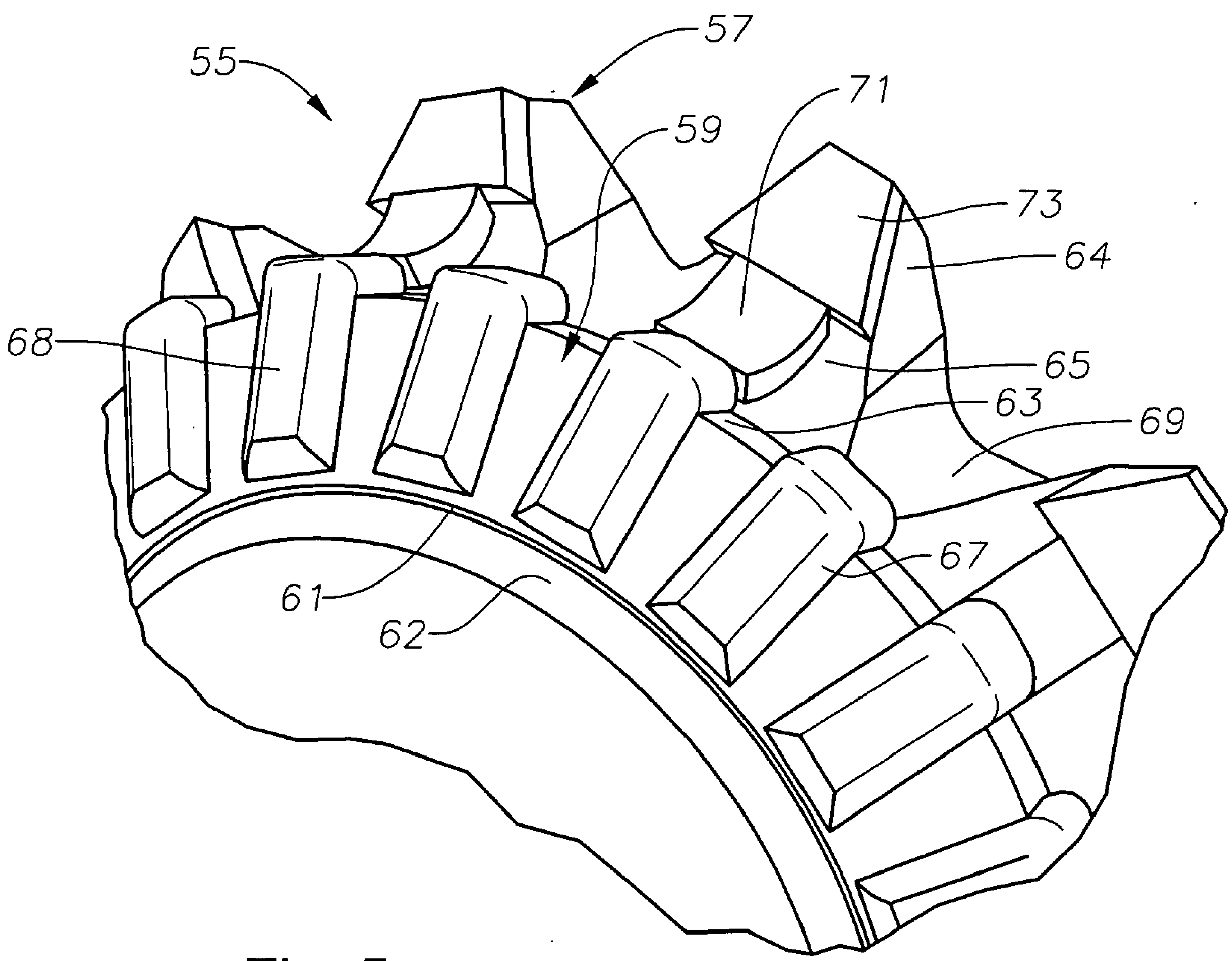

Fig. 5

BIT GAGE HARDFACING

FIELD OF THE INVENTION

[0001] This invention relates in general to earth boring bits, and in particular to bits having hardfacing on the bit gage surface to reduce wear.

BACKGROUND OF THE INVENTION

[0002] A common type of earth boring bit has rotatable cones. Each cone is rotatably mounted to a bearing pin that depends from the body of the bit. The cones have cutting elements that disintegrate the earth formation as the bit body is rotated. The cutting elements may comprise tungsten carbide compacts press-fitted into holes in the supporting metal of the cones. Alternately, the cutting elements may be milled teeth that are integrally formed from the cone metal.

[0003] Each cone has a gage surface that engages the side of the bore hole as the bit rotates. In milled teeth cones, the teeth of the heel row, which is the row closest to the borehole wall, have gage sides that typically blend into the gage surface. The gage surface is an annular area that extends from a backface of the cone and joins the gage sides of the heel row teeth. Often trimmer cutting elements will be located between the heel row primary cutting elements at the outer periphery of the gage surface.

[0004] For many years, manufacturers have applied hardfacing to the milled teeth to reduce wear. Typically, the hardfacing is applied to the entire tooth, including its gage side, nose side, leading flank and trailing flank. In milled teeth bits, the trimmer cutting elements may be formed of a hardfacing deposit.

[0005] Under very abrasive formation conditions, the gage surface will round over and wear away the hardfacing. The underlying steel areas of the gage surface become exposed. Once exposed, the gage surface has very little resistance to wear under abrasive conditions. The gage surface will quickly wear, and the useful life of the bit will then be over because the bit will no longer be able to drill in-gage, causing bearing failure.

[0006] To reduce wear to the gage surface of milled teeth bits, manufacturers have extended the hardfacing from the gage sides of the heel row teeth to the inner edge of the gage surface. These hardfacing deposits were spaced apart from each other around the gage surface. The spaces on the gage surface between the hardfacing deposits were recessed and free of hardfacing.

SUMMARY OF THE INVENTION

[0007] In this invention, the gage surface has a hardfacing of carbide particles in a metallic matrix. The hardfacing extends from the inner edge of the gage surface to the cutting elements of the heel row and to trimmer cutting elements. A plurality of channels on the gage surface allows for the displacement of material generated by the cutting elements and trimmers.

[0008] In the preferred embodiment, the hardfacing covers the entire gage surface and the heel row teeth. Hardfacing bars or deposits are formed on the gage surface and gage sides of the teeth. The spaces between the bars define the channels. The channels extend from the inner edge of the gage surface to an outer periphery of the gage surface. A first group of the hardfacing bars extends from the inner edge of the gage surface to the valleys between the teeth, forming trimmer cutting elements. The second group of hardfacing bars extends from the inner edge of the gage surface onto the gage side of the heel row teeth.

[0009] In one embodiment, a first type of hardfacing is applied to portions of the teeth other than the gage sides. The hardfacing on the gage surface and the gage sides of the teeth is preferably more wear resistant than the first type but is not as tough.

BRIEF DESCRIPTION OF THE DRAWINGS

[0010] **FIG. 1** is a perspective view of an earth boring bit constructed in accordance with this invention.

[0011] **FIG. 2** is a sectional view of one of the heel row teeth of the bit in **FIG. 1**, taken along the line **2-2** of **FIG. 3**.

[0012] **FIG. 3** is an enlarged elevational view of the gage side of a heel row tooth of the bit of **FIG. 1**.

[0013] **FIG. 4** is an elevational view of the top side of two of the heel row teeth of the bit of **FIG. 1**, shown prior to applying the hardfacing.

[0014] **FIG. 5** is an enlarged perspective view of part of a cone of the bit of **FIG. 1** that is not shown in **FIG. 1**.

DETAILED DESCRIPTION OF THE INVENTION

[0015] Referring to **FIG. 1**, the earth boring bit shown has a body **11** with a threaded upper end **13** for securing to a drill string. In this example, three cones **15** are rotatably mounted to depending bearing pins (not shown) of body **11**. Body **11** has lubricant reservoirs for supplying lubricant to the bearings supporting each cone **15**. A compensator **17** equalizes pressure differential between fluid in the borehole with the pressure of the lubricant. Body **11** has nozzles **19** for discharging drilling fluid, the drilling fluid sweeping cuttings from the borehole and returning them to the surface.

[0016] Each cone **15** has a generally frusto-conical main portion containing at least two rows of cutting elements, including a heel row **21**. Heel row **21** is the row closest to a gage surface **23**. Gage surface **23** engages the sidewall of the borehole as body **11** and each cone **15** rotates. Gage surface **23** thus determines the diameter of the borehole. In this embodiment, the cutting elements are milled teeth that are machined from the supporting metal of each cone **15**. Alternately, cones **15** could have tungsten carbide inserts or compacts press-fitted into holes formed in the supporting metal of cones **15**.

[0017] Referring to **FIG. 3**, a portion of gage surface **23** of one of the cones **15** is shown. Gage surface **23** is a frusto-conical surface that has an inner edge **25** joining a backface **26** of cone **15**. Backface **26** is a flat machined surface that is perpendicular to the axis of rotation of cone **15**. When cone **15** is installed on a bearing pin, backface **26** will be closely spaced to a machined surface (not shown) on one of the bit legs of bit body **11**. Gage surface **23** extends outward from inner edge **25** to the frusto-conical main portion of cone **15**. The outer periphery of gage surface **23** joins gage sides **29** of heel row teeth **21** and valleys **27**, which are located between heel row teeth **21**. In cones **15**, gage sides **29** are flush with gage surface **23**.

[**0018**] Referring to **FIG. 2**, each tooth of heel row **21** has an underlying tooth stub **31** that is machined from the steel body of cone **15**. Tooth stub **31** has a nose side **33** that is typically flat and faces toward the central axis of rotation of bit body **11**. Tooth stub **31** has a large recess **35** on its gage side **29**. Recess **35** is preferably a concave surface formed at a selected radius. Recess **35** leads to a crest **37**, which, prior to hardfacing, is greatly truncated in length because of the depth of recess **35**. Tooth stub **31** also has leading and trailing flanks **38 (FIG. 4)** that face into and away from the direction of rotation of cone **15**. **FIG. 4** shows two of the tooth stubs **31** from a top view prior to hardfacing, looking down on crests **37**.

[**0019**] Referring again to **FIGS. 2 and 3**, a first type of hardfacing **39** is located on nose side **33**, flanks **38** and crest **37** of each tooth stub **31**. In this example, first type hardfacing **39** is not located in the tooth stub recess **35**, or on the underlying steel body of cone **15** at gage surface **23**. First type hardfacing **39** is also used to form trimmers **47**, which are small cutting elements located in valleys **27** at the junction with gage surface **23**. Trimmers **47** are smaller in height, width, and depth than the primary teeth of heel row **21**. The thickness of first type hardfacing **39** may be the same as prior art hardfacing, which is typically up to about 0.125 inch. After application, first type hardfacing **39** is preferably not shaped or smoothed by grinding, although it could be, if desired.

[**0020**] A second type of hardfacing **40** entirely covers gage surface **23**, and in the preferred embodiment, fills in recess **35 (FIG. 2)** of each tooth stub **31**. First type hardfacing **39** is applied to and becomes part of crest **37**, and also overlays the portion of the second type hardfacing **40** that fills in recess **35**. First type hardfacing **39** at crest **37** extends to gage side **29** of each tooth stub **31**.

[**0021**] Referring also to **FIG. 3**, long and short hardfacing deposits or bars **41, 45** are formed with the second type of hardfacing **40** on gage surface **23**. The term "bars" is not used in a limiting sense to refer to rectangular shapes, rather the shape can be varied. The terms "long" and "short" are used only for convenience and not in a descriptive sense. Long and short hardfacing bars **41, 45** alternate with each other in this embodiment, but more than one short bar **45** could locate between two long bars **41**, particularly in larger diameter bits. Hardfacing bars **41, 45** extend generally along radial lines emanating from an axis of rotation of cone **15**, but they could be inclined relative to the radial lines. Hardfacing bars **41, 45** could have the same widths, or the widths could differ.

[**0022**] Long bars **41** extend outward from gage surface inner edge **25** onto gage side **29** of each tooth of heel row **21**. In the example shown, the outer end **43** of each long hardfacing bar **41** terminates short of crest **37**, but it could extend completely to crest **37**, entirely covering gage side **29**. Preferably, each short hardfacing bar **45** extends from gage surface inner edge **25** to one of the valleys **27** between the teeth of heel row **21**. In this example, the outer end of each short hardfacing bar **45** terminates at one of the trimmer cutting elements **47**, which is formed of the first type of hardfacing **39**. Each trimmer **47** protrudes outward beyond valley **27** and has a gage side that is flush with one of the short hardfacing bars **45**.

[**0023**] Hardfacing bars **41, 45** have opposed lateral edges **49, 51** that are circumferentially separated from each other and generally parallel, as shown in **FIG. 3**, however due to the welding process, lateral edges **49, 51** will be irregular. Lateral edges **49, 51** define flow channels **53** that extend from gage surface inner edge **25** to valleys **27**. Each flow channel **53** is generally parallel to hardfacing bars **41, 45** in this embodiment, and substantially parallel to a radial line eminating from the axis of rotation of cone **15**. Lateral edges **49, 51** form the sides of flow channels **53**, and the base of each flow channel **53** is formed by the second type of hardfacing **40**.

[**0024**] First and second types of hardfacing **39, 40** are formed of carbide particles in a metallic matrix. Hardfacing bars **41, 45** are not pre-formed, rather they are formed at the same time they are being applied to cone **15 (FIG. 1)**. Preferably, first and second types of hardfacing **39, 40**, including hardfacing bars **41, 45**, are applied by a welding torch in a conventional manner. One method of applying second type hardfacing **40** to gage surface **23** is to first apply a continuous uniform thickness layer of second type hardfacing **40** on gage surface **23**, then build up hardfacing bars **41, 45** on the continuous uniform thickness layer.

[**0025**] After hardfacing types **39, 40** are applied, the gage sides of hardfacing bars **41, 45**, trimmers **47** and crests **37** are ground smooth to the desired gage diameter. Normally, lateral edges **49, 51** of hardfacing bars **41, 45** will be left in the as welded condition, but they could be ground smooth if desired. The remaining portions of first and second types of hardfacing **39, 40** are also preferably left in the as-welded condition, but portions could be ground smooth if desired. The remaining as-welded portions of first type of hardfacing **39** include nose side **33**, flanks **38**, and crest **37** of each tooth stub **31** and trimmers **47**. The remaining as-welded portions of second type of hardfacing **40** include the bases of channels **53**.

[**0026**] The thickness of hardfacing bars **41, 45** prior to grinding may be approximately the same as the underlying continuous layer of second type hardfacing **40** or it could differ. After grinding, preferably each hardfacing bar **41, 45** protrudes at least 0.015 inch from the base of channel **53**, making each channel **53** at least 0.015 inch in depth. Prior to applying first and second types of hardfacing **39, 40** the underlying supporting steel body of cone **15** at gage surface **23** will be machined to a dimension to accommodate the increased thickness due to hardfacing bars **41, 45**.

[**0027**] In the preferred embodiment, first type of hardfacing **39** is of a tougher, but less wear-resistant material than second type of hardfacing **40**. The difference in wear resistance of drill bit hardfacing may be accomplished in different ways as explained in U.S. Pat. No. 6,360,832. One way is by increasing the density of the carbide particles within second type of hardfacing **40** over that in first type of hardfacing **39**. As a result, there will be more volume of carbide particles per unit volume in second type of hardfacing **40** than in first type of hardfacing **39**. This may be done by making the majority of carbide particles in the hardfacing tubes for second type of hardfacing **40** smaller than the majority of carbide particles in the hardfacing tubes used to form first type of hardfacing **39**. The term "majority" as used herein means by comparison in weight, not in total number of particles, because the carbide particles within first and second types of hardfacing **39**, **40** may be of multiple sizes. If so, the size that makes up the majority of particles in each of the tubes by weight for hardfacing type **39** compared to the total weight of the other particles, will differ in dimension from the tubes for hardfacing type **40**. The smaller size carbide particles can be more tightly packed together than larger particles, resulting in less matrix metal and thus a greater volume density per unit volume.

[**0028**] The carbide particles are placed within a welding tube as filler. Preferably the carbide filler has a weight of about 65 to 70% of the total weight of the tube. In one example, tubes for first type of hardfacing **39** may use the following carbide particles as filler:

[**0029**] 16/20 mesh cemented tungsten carbide pellets 32.75%

[**0030**] 20/30 mesh cemented tungsten carbide pellets 34.75%

[**0031**] 20/30 mesh crushed cemented tungsten carbide 15%

[**0032**] 60/85 mesh spherical cast tungsten carbide 15%

In the same example, tubes for second type of hardfacing **40** may contain the following carbide particles:

[**0033**] −30 +40 mesh cemented tungsten carbide pellets 37.5%

[**0034**] −30 +40 mesh crushed cemented tungsten carbide 10%

[**0035**] −35 +85 mesh spherical cast 50%

[**0036**] In both grades, the cemented carbide referred to as pellets comprises granules that have generally spherical shapes. These pellets are not true spheres, but lack the corners, sharp edges and angular projections commonly found in crushed and other non-spherical carbide grains or particles. Cemented carbide pellets comprise crystals or particles of tungsten carbide sintered together with a binder, usually cobalt, into a generally spherical pellet configuration.

[**0037**] Another way to accomplish higher density is to increase the amount of filler in the rod, which is the percentage of carbide particles by weight to the steel alloy body of the tube. The steel alloy forms the matrix for the hardfacing. If the carbide particles in each rod were the same size, the rod with the higher percentage of filler by weight would be denser.

[**0038**] **FIG. 5** shows a third cone **55** for the bit of **FIG. 1**. In this embodiment, third cone **55** differs from the two cones **15** shown in **FIG. 1** in that heel row **57** is offset from gage surface **59**. That is, heel row **57** is spaced closer to the nose of cone **55** than heel rows **21** of cones **15** (**FIG. 1**). Alternately, third cone **55** could be configured with heel row **57** being non-offset as in the other two cones **15**. As another alternative, third cone **55** could have every other tooth of heel row **57** flush with gage surface **59**, with the alternating teeth being staggered.

[**0039**] In **FIG. 5**, gage surface **59** has an inner circumferential edge **61** at backface **62** and an outer circumferential edge **63**. As in the first embodiment, a first type of hardfacing **64** is applied over the nose side, crest, and flanks of the teeth of heel row **57**. A second type of hardfacing **65** is applied over gage surface **59**, and the portion of the cone **55** between gage surface **59** and heel row **57**. Short and long hardfacing bars **67**, **68** are formed of second type hardfacing **65** on gage surface **59**. Hardfacing bars **67**, **68** alternate with each other and are spaced apart from each other with the spaces between forming channels for fluid flow. The edges of the protruding hardfacing bars **67**, **68** form the sides of the channels, and the base of each channel is formed by less thick second type hardfacing **65** between the edges.

[**0040**] Hardfacing bars **67**, **68** extend from inner edge **61** to outer edge **63** of gage surface **59**. In this embodiment, hardfacing bars **67**, **68** are approximately the same width, but they could differ. Each of the long hardfacing bars **68** aligns with one of the heel row teeth **57**. Short hardfacing bars **67** align with valleys **69** between teeth of heel row **57**. The outer end of each short hardfacing bar **67** protrudes above each valley **69** a short distance to form a scraper or trimmer cutting element. Alternately, the outer portion that forms the trimmer element could be formed of the first type of hardfacing **64**.

[**0041**] In this example, extension bars **71** of the second type of hardfacing **65** extend from the outer end of each long hardfacing bar **68** to a gage side **73** of each heel row tooth **57**. Preferably, extension bars **71** also extend up gage side **73**, forming a layer of the second hardfacing **65** on the gage side of heel row teeth **57**. Extension bars **71** on gage side **73** may terminate short of the crest, as in the first embodiment, or extend completely to the crest.

[**0042**] As in the first embodiment, the gage sides of hardfacing bars **67**, **68** are ground to a desired diameter, and the portions of hardfacings **64**, **65** not at the gage diameter left as welded. As in the first embodiment, first type of hardfacing **64** is of a tougher but less wear-resistant material than second type of hardfacing **65**.

[**0043**] The invention has significant advantages. The hardfacing bars in both embodiments, when combined with the underlying hardfacing layer, create a hardfacing that is thicker than hardfacing used in the prior art on the gage surface. The spaces between the hardfacing bars provide channels for drilling fluid flow. The bases of the channels are protected also by the hardfacing. The tougher hardfacing type, which is used in areas of high impact such as on the teeth, reduces cracking of the hardfacing deposit. The more wear resistant but more brittle hardfacing, which is used on the surfaces that slide against the borehole sidewall, better reduces wear of the cone metal than the first hardfacing type.

[**0044**] While the invention has been shown in only two of its forms, it should be apparent to those skilled in the art that it is not so limited but is susceptible to various changes without departing from the scope of the invention. For example, although the drawings show the hardfacing bars extending generally along radial lines from the axis of rotation of the cone, they could be inclined either into or away from the direction of rotation of the cone. In such instance, the hardfacing bars would be inclined relative to radial lines of the axis of rotation of the cone. Also, as mentioned, the hardfacing bars could be applied to the gage surface of a tungsten carbide insert bit. In a tungsten carbide insert bit, the heel row cutting elements and the trimmers would be formed of tungsten carbide and pressed fitted into mating holes in the cone body.

1. An earth boring drill bit, comprising:

at least one rotatable cone having a generally frusto-conical portion containing cutting elements for engaging a borehole bottom and having a gage surface for sliding contact with a sidewall of the borehole as the bit rotates, the gage surface having a circular inner edge concentric with an axis of rotation of the cone;

the cutting elements including a heel row adjacent the gage surface and a plurality of trimmer cutting elements, each spaced between two of the cutting elements of the heel row and located at a junction with the gage surface and the frusto-conical portion;

the gage surface having a hardfacing of carbide particles in a metallic matrix, the hardfacing extending from the inner edge of the gage surface to the cutting elements of the heel row and also extending from the inner edge of the gage surface to the trimmer cutting elements; and

a plurality of channels on the gage surface leading from the inner edge for drilling fluid flow.

2. The bit according to claim 1, wherein the hardfacing comprises:

a plurality of hardfacing bars of carbide particles in a metallic matrix separated from each other, with spaces between the hardfacing bars defining the channels and being overlaid with the hardfacing.

3. The bit according to claim 1, wherein each of the channels has side edges defined by portions of the hardfacing and a base connecting the side edges, the base being formed of portions of the hardfacing.

4. The bit according to claim 1, wherein:

the channels extend from the inner edge of the gage surface to the frusto-conical portion of the cone.

5. The bit according to claim 1, wherein the channels extend generally along radial lines emanating from an axis of rotation of the cone.

6. The bit according to claim 1, wherein the trimmer cutting elements are formed of carbide particles in a metallic matrix and are integrally formed with the hardfacing.

7. The bit according to claim 1, wherein:

the cutting elements of the heel row comprise milled teeth machined on the frusto-conical portion of the cone; and wherein

the teeth of the heel row have gage sides onto which the hardfacing extends.

8. The bit according to claim 1, wherein the hardfacing comprises:

a first type of hardfacing welded onto and covering at least portions of each of the teeth of the heel row; and

a second type of hardfacing welded onto the gage surface, the second type being formed of a material having more wear resistance than the first type of hardfacing.

9. An earth boring drill bit, comprising:

at least one rotatable cone having a gage surface for engaging a sidewall of a wellbore as the bit rotates, the gage surface having an inner circumferential edge concentric with an axis of rotation of the cone;

a heel row of primary cutting elements on the cone adjacent the gage surface; and

a first group of hardfacing bars extending from the inner edge of the gage surface to the primary cutting elements of the heel row; and

a second group of hardfacing bars extending from the inner edge of the gage surface to an outer periphery of the gage surface between the primary cutting elements of the heel row, the first and second groups of hardfacing bars comprising carbide particles in a metallic matrix.

10. The bit according to claim 9, further comprising:

a hardfacing layer of carbide particles in a metallic matrix substantially covering spaces of the gage surface between the first and second groups of hardfacing bars.

11. The bit according to claim 9, further comprising:

a hardfacing layer of carbide particles formed on at least portions of the heel row of primary cutting elements; and

wherein the first and second groups of hardfacing bars are formed of a grade of material having a greater wear resistance than the hardfacing layer.

12. The bit according to claim 9, further comprising:

a plurality of trimmer cutting elements formed of hardfacing material, each of the trimmer cutting elements being located between two of the primary cutting elements of the heel row and on an outer periphery of the gage surface; and

wherein the second group of the hardfacing bars joins the trimmer cutting elements.

13. The bit according to claim 9, wherein the hardfacing bars extend generally along radial lines emanating from an axis of rotation of the cone.

14. The bit according to claim 9, wherein:

the cutting elements of the heel row comprise milled teeth machined on the cone; and

wherein the teeth of the heel row have gage sides onto which the first group of hardfacing bars extend.

15. An earth boring drill bit, comprising:

at least one rotatable cone having a gage surface for engaging a sidewall of a wellbore as the bit rotates, the gage surface having an inner circumferential edge substantially concentric with an axis of rotation of the cone;

a heel row of teeth located on the cone, each of the teeth having a crest, a nose side, a gage side, and leading and trailing flanks;

a first type of hardfacing of carbide particles in a metallic matrix substantially covering the nose side, the crest, and the flanks of the teeth of the heel row;

a second type of hardfacing of carbide particles in a metallic matrix extending from the inner circumferential edge to an outer periphery of the gage surface, the second type of hardfacing being of a grade having more wear resistance than the first type of hardfacing; and

a plurality of channels in the second type of hardfacing, each channel extending from the inner circumferential edge to the outer periphery of the gage surface, the channels being spaced circumferentially apart from each other around the gage surface, the base of each of the channels being defined by the second type of hardfacing.

16. The bit according to claim 15, wherein portions of the second type of hardfacing extends onto portions of the gage sides of the teeth of the heel row.

17. The bit according to claim 15, further comprising a plurality of trimmer cutting elements, each of the trimmer elements being located between two of the teeth of the heel row and being formed of the first type of hardfacing.

18. The bit according to claim 15, wherein the channels extend generally along radial lines emanating from an axis of rotation of the cone.

19. The bit according to claim 15, wherein the second type of hardfacing extends onto part of the gage side of each of the heel row teeth, but terminates short of the crest.

20. The bit according to claim 15, wherein:

at least some of the teeth of the heel row are offset toward a nose of the cone from the outer periphery of the gage surface; and wherein the bit further comprises:

a plurality of spaced apart extension bars that extend from the outer periphery of the gage surface to the gage sides of said at least some of the teeth of the heel row, the extension bars being formed of the second type of hardfacing.

* * * * *